



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4749-1
Job Sheet 170286



Part No: D4749-1

Job Qty: 12 ea

Part Name: Spacer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/12/18

Job Tracking No:

Created By: Mario Poulin

Due Date: 1/26/18

Type: Stock

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 12.11.27 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea	1/25/18	1/25/18	0.00	0.00	Start Up Machining-3		 DAS 23 1/26/18 9-89 ST183
100	Hardinge	12 pcs	1/26/18	1/26/18	0.00	1.36	Hardinge		
110	QC	12 pcs	1/26/18	1/26/18	0.00	0.00	QC8		
130	Packaging	12 pcs	1/26/18	1/26/18	0.00	0.00	Packaging3-2		
140	QC21-SA	12 Ea	1/26/18	1/26/18	0.00	0.00	QC21		

Part Op Descriptions: 100 - 1-TURN AS PER FOLIO FB & DWG

DAS
21
9-89

FEB 05 2018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M17-4-R0.375	0	3	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Spacer	0.194Inches + 0.002 - 0.005	0.196 0.189	Diameter	
2	Spacer	0.245Inches + 0.000 - 0.005	0.245 0.240	Diameter	
3	Spacer	0.160Inches ± 0.010	0.170 0.150		
4	Spacer	0.025Inches + 0.010 - 0.100	0.035 (0.075)		
5	Spacer	45.000Degrees ± 0.500	45.500 44.500	Angle	

Plex 1/12/18 2:07 PM dart.poulin.mario

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: Part No: NCR No: Date : 	DISPOSITION Operation 02/02/18 Job No: 170286	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐															
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		QTY Effective : _____	MRB (QSI042) Approval																														
		Disposition																															
		Completed By																															
		Lead hand / Supervisor Approval Verification																															
		QC / QA Coordinator Approval																															
S038541 Spacer		FAULT CATEGORY <table style="width: 100%;"> <tr> <td>☐ Temperature/Cure</td> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Set-up</td> <td>☐ Folio/Program</td> <td>☐ Outside Dimensions</td> </tr> <tr> <td>☐ BOM/Route</td> <td>☐ Grain</td> <td>☐ Over/Under tolerance</td> </tr> <tr> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☐ Part Incorrect</td> </tr> <tr> <td>☐ Inspection Incomplete/Unqualified</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Contamination</td> <td>☐ Out of Sequence</td> <td>☐ Part Moved</td> </tr> <tr> <td>☐ Countersink</td> <td>☐ Off-set</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Cut Too Short</td> <td>☐ Mislabeled</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Instructions Incomplete/Unclear</td> <td>☐ Fit/Function</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Drill Holes</td> <td>☐ Misaligned/off center</td> <td>☐ Turning Sequence</td> </tr> </table>		☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Contamination	☐ Out of Sequence	☐ Part Moved	☐ Countersink	☐ Off-set	☐ Drawing	☐ Cut Too Short	☐ Mislabeled	☐ Finish	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence
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PART NO: D4749 - 1 Original Serial #: S038541 Revision: Operation: Start up Operation Change No:																																	
Environment: Des: Doc/D: Equip/Tool: Handling/I: Mate: Internal Transp: Tribal Knowledge:		Substation: ☐ Past Expiry Date: ☐ Misidentified: ☐																															
Process improvement: ☐ Manufacturing Process: ☐ Past Due: ☐		Marks/Chatter: ☐ OTHER : _____																															